

Work Order ID 127859

127859

December-17-14 1:57:52 PM

Page 1

Item ID: D3030-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lock
 Start Date: 12/17/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MVS Date: 14-12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3030	Rev A								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 26945 a) Possible supplier: ACS-NAI Ltd b) Order P/N
 B83603-1c) Material: 2024-T351 (QQ-A-225/6)d) 0.010" max diff. Between
 0.525" dim each sidee) All diameters concentric within 0.005 T.I.R.f) All
 dimensions are in inchesg) Tol

CX 15/01/06 12

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

12x 8015-01-13

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

(12)

DAS
38
0.00

JAN 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: Sto15 Memo	0.00 0.00				12		JAN 14 2015	DAS 86 9-88
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MCS 15-01-14	15-1-14

DQA: _____ Date: _____



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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 127859

127859

Parent Item: D3030-1

D3030-1

Parent Item Name: Lock

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B 01.06.08 Removed chemical conversion EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B83603-1		Purchased	No			110	Each	0.0000	1	12			
B83603-1									**				
Lock													

2x 8P15-01-13

DQA: _____ Date: _____



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Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

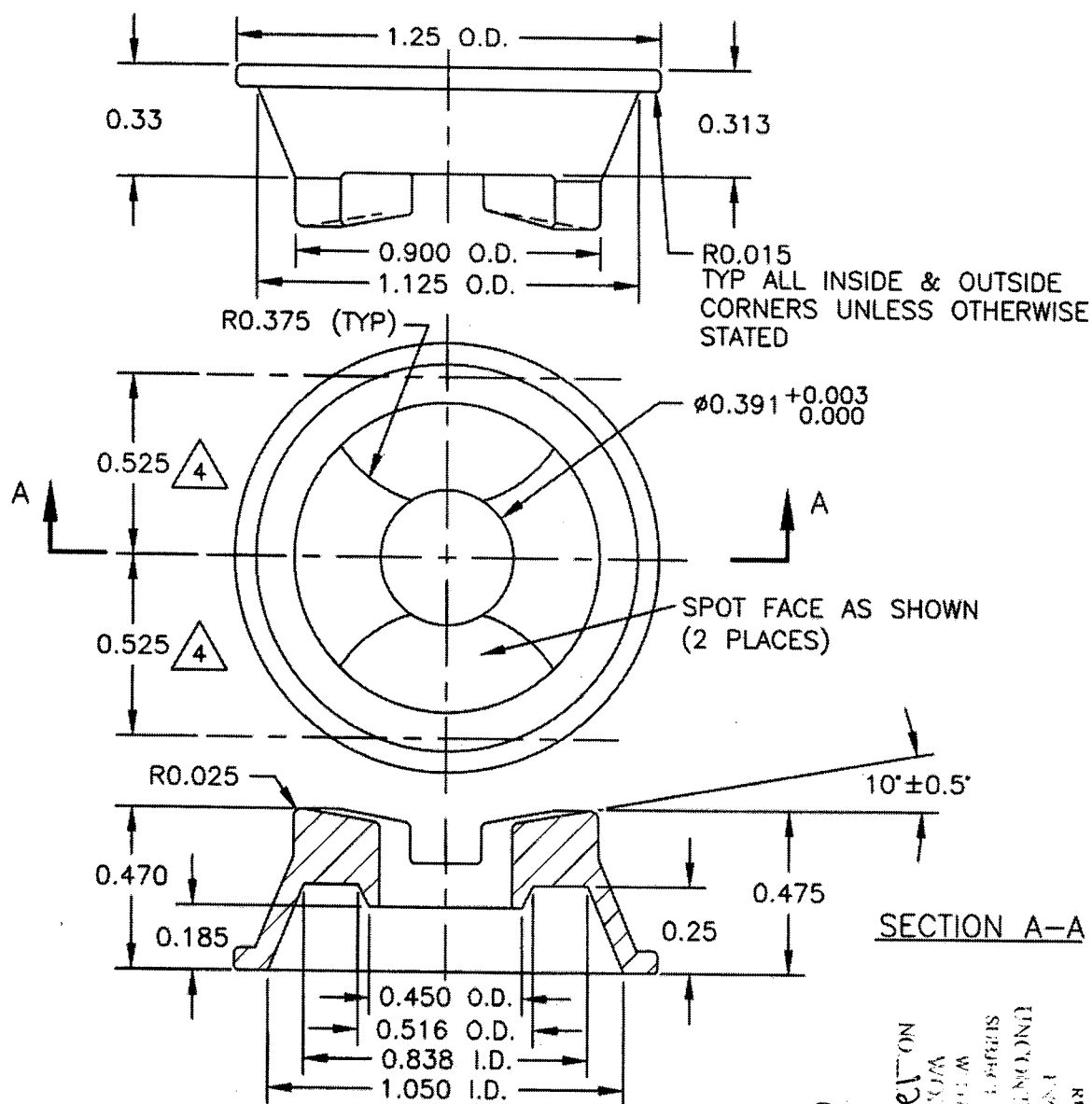
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3030	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE LOCK	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3030-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83603-1
- 2) MATERIAL: 2024-T351 (QQ-A-225/6)
- 3) ALL DIAMETERS CONCENTRIC WITHIN 0.005 T.I.R.
- 4) 0.010 MAX DIFF. BETWEEN 0.525 DIM EACH SIDE.
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHO C
RT
IN
UNO
SIB
W
W
NO-127859

RELEASED
01.05.30

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26945**

Purchase Order Date 1/6/2015

PO Print Date 1/6/2015

Page Number 1 of 1

Order From :

VU-ACS001

EMTEQ
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 204-772-9922

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	B83603-1 AS PER DWG D3030 REV. A B127859	Lock	1/14/2015 Yes 1/14/2015		12.00 Each	\$85.00	\$1,020.
						Line Total:	\$1,020.
2	71401-45 Procurement Quality Clauses A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT	PROCUREMENT QUALITY CLAUSES	1/14/2015 No 1/14/2015		1.00	\$0.00	\$0.
						Line Total:	\$0.
						PO Total:	\$1,020.

8915-01-13

W
col

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 1/6/2015



Packing Slip

EMTEQ Canada Ltd.

25 Dunlop Avenue

R2X 2V2 Winnipeg

Canada

Tel : 204-772-9922

Fax : 204-772-7568

Delivery No. : 5267
Delivery Date : 01/09/2015
SO No. : 32489
Your Reference : PO: 26945
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Item	Description Batch Number	Total		Qty		Delivery Date
		Ordered	Unit	Delivered		
B83603-1	LOCK 14-1162	12	EA	12		01/12/2015
Ship via FedEx overnight to Acct # 151793240 Email: Clavoie@dartaero.com ph: 613-632-9577 FORM ONE CERTIFICATE PROVIDED. SP15-01-13						
Packages: 0 Gross Weight: 0.00 Net Weight:						

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

0.00

Remarks

Certification Statement

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:



Form Tracking No.: 32489-1

Contract/Invoice:
PO: 26945

Production Order: PR1300013838

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Lock	B83603-1	12	14-1162	New

Remarks:

THE ABOVE ITEM CONFORMS TO RELEASED DESIGN DATA IN ACCORDANCE WITH DWG B83603 (Rev. NC).

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed ACS-NAI (dba EMTEQ) in accordance with a AS9100 Quality Assurance System.

Signature _____

Name TIM SINCLAIR

Date (dd mmm yyyy) 12-Jan-15

~~User/Installer Responsibilities:~~ This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.